DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 50.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-002815
Date Inspected: 06-Jun-2008

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Jiangyin

OSM Arrival Time: 1400
OSM Departure Time: 2300
Location: Shanghai, China

CWI Name:	Chen Chih-Ming / An Qingxiang			**CWI Present:**	☑ Yes	☐ No	
Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**Rod Oven in Use:**	☐ Yes	☐ No	☑ N/A
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Approved WPS:**	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: OBG side and bottom panels and tower skin p

Summary of Items Observed:

On this day CALTRANS OSM Quality Assurance Inspector (QA) Steve Hall was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG new assembly bay 2

QA noted that ZPMC had completed SAW on SEG-022A-003 SP-601 to SP-561.

QA observed ZPMC qualified welding personnel perform FCAW root weld on SEG-021A-002 SP-091 to SP-118 following the guide lines of WPS# WPS-B-T-2131-B-U2-F-1. QC monitored the welding process continuously throughout the evening. The welding parameters as measured with Quality Controls calibrated instruments appeared to be in conformance with the posted WPS's and were as follows:

Volts: 28 Amps: 257 Travel speed: 470mm/min

QA observed ZPMC qualified welding personnel perform SAW on SEG-023-012 SP-749 to SP-511 following the guide lines of WPS# WPS-B-T-2221-B-L2c-S-1. QC monitored the welding process continuously throughout the evening. The welding parameters as measured with Quality Controls calibrated instruments appeared to be in conformance with the posted WPS's and were as follows:

Volts: 30 Amps: 526 Travel speed: 653mm/min

QA observed ZPMC qualified welding personnel perform SAW on SEG-024A-006 SP-603 to SP-563 following the guide lines of WPS# WPS-B-T-2221-B-L2c-S-1. QC monitored the welding process continuously throughout the evening. The welding parameters as measured with Quality Controls calibrated instruments appeared to be in conformance with the posted WPS's and were as follows:

Volts: 31 Amps: 531 Travel speed: 603mm/min

QA observed ZPMC qualified welding personnel back gouging joint SEG-021A-008 SP-747A to SP-509A. Other general observations include ZPMC personnel grinding side and bottom panels and weld bevel prep.

New Tower Bay 1

QA performed 10% Ultrasonic Testing (UT) verification on the following tower skin plate joints: SSD1-SA173K/K-9A, 11A, 12A and 13A, SSD1-SA178C/D-25B, 7B, 10B and 11B. All welds that were scanned appeared to compliant with AWS D1.5 2002 and the contract documents.

New Tower Bay 2

QA attempted to perform 10% UT on joint ESD1-SA107A/J-19 however, QA and QC could not locate the tower skin plate containing the above mentioned joint.

Summary of Conversations:
Only general conversations were held between QA and QC concerning this project.
Comments
This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Patrick Lowry (858)-344-2712, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By:	Hall,Steven	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer